

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009629**Date Inspected:** 02-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Wan Wen Zhong, Chen Ying Xin.			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	Tower	

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Tower Jetty South Tower Lift 1 Mechanical Piping Support on exterior of Skin D

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ETM-1A/C-1, 2, 3, 4, 27, 28, 29, 30

Tower Jetty East tower Lift 1 Grating Bracket (After Repair)

This QA inspector performed random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The members are identified as Tower Components. The weld designations reviewed are as follows.

GGSA-30PLAN-47.6M-1

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

GGSA-4PLAN-18M-1

GGSA-2PLAN-15M-5

Tower Jetty East Tower Lift 1 Grating Bracket

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

GGSA-28PLAN-47.6M-3

GGSA-28PLAN-47.6M-4

GGSA-28PLAN-47.6M-5

GGSA-30PLAN-47.6M-1

GGSA-30PLAN-47.6M-2

This QA Inspector has issued the Green Tag for the following parts:

South Tower Lift 1 Mechanical Piping Support on exterior of Skin D: Green Tag # 10664

East Tower Lift 1 Grating Bracket: Green Tag # 10447

South Tower Lift 3 skin C & skin D Stiffener Gusset Plate: Green Tag # 9840

South Tower Lift 3 skin C/D corner diagonal stiffener to Diaphragm: Green Tag # 10645

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

FCAW welding of weld joint 4A located on NSD1-SPSA3-70.

Welder is identified as 040261. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U5-F.

SAW welding of weld joint 2B located on ED1-STSA3-2-109M-2.

Welder is identified as 052917. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 7A located on ED1-A6003-4.

Welder is identified as 040582. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

FCAW welding of weld joint 1A (REPAIR) located on NSD1-SPSA3-66.

Welder is identified as 048627. ZPMC CWI is identified as Mr. Gong Liang Zhu.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REAPIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
